

Date: Thursday, 22/01/2009 8:12:29 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSY WELDMENT
Job Number	: 45048		
Estimate Number	: 13418		
P.O. Number	:	Part Number	: PB674300107
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.5
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 43063	Material	:
Written By	:	Due Date	: 28/02/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>MF 09-01-22</u>		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PB674300147	Base Assembly
-----	-------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Base Assembly

batch:- 45027MF 09-03-02

2.0	PB6743001205	Outer Tube
-----	--------------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Outer Tube

batch:- 41485MF 09-03-02

3.0	PB6743001197	Outer Tube
-----	--------------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Outer Tube

batch:- 45261MF 09-03-02

4.0	PB6743001211	Square Tubing
-----	--------------	---------------



Comment: Qty.: 6.0000 Each(s)/Unit Total: 12.0000 Each(s)

Square Tubing

batch:- 41989MF 09-03-02

5.0	PB6743001209	Square Tubing
-----	--------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Square Tubing

batch:- 43073MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSY WELDMENT

Job Number: 45048

Part Number: PB674300107

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	PB6743001201	Square Tubing
-----	--------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Square Tubing
batch:- 41484

MF 09-03-02

7.0	PB6743001203	Square Tube
-----	--------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Square Tube
batch:- 41907

MF 09-03-02

8.0	PB6743001207	Square Tube
-----	--------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Square Tube
batch:- 43199

MF 09-03-02

9.0	PB6743001219	Angled Male Eye
-----	--------------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Angled Male Eye
batch:- ~~B 41908~~ 41908

MF 09-03-02

10.0	D34405	Contoured Detent Clip Base (Supersedes B
------	--------	--



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Contoured Detent Clip Base
batch:- 1 x 24002, 1 x 41454

MF 09-03-02

11.0	D34407	Detent Clip Base (Supersedes B67-43001-2
------	--------	--



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Detent Clip Base
batch:- B 41455

MF 09-03-02

12.0	D344015	Contoured Male Eye (Supersedes B67-43001
------	---------	--



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Contoured Male Eye
batch:- 41453

MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 8:12:29 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSY WELDMENT

Job Number: 45048

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(X2)

Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001

*** ensure no burn thru after welding in tube -205 and -197 only where bushing -265 ***

PL 09.04.01

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 09.04.01 (2)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/02 (X2)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

mask inside of D3440-5, D3440-7 and D3440-15 prior to paint

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:15
3200
11:45

M 18/44
11/07/07

BR 09-04-7

(2)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/07 (2)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

MIX

PL 09-04-07

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/08

Job Completion



MF 09-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1.8 NO PAINT THIS
AREA ALL AROUND -3!
3 PLACES

